

5129539



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6202

Job Sheet 182348



Part No: D6202

Job Qty: 20 ft

DAS
13
9-89

Part Name: I-Beam Extrusion



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/23/18

Job Tracking No:

Created By: Patrick Lussier

Due Date: 8/29/18

Description:

Type: Stock

Note: DWG REV A

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing - Ft	20 ft		8/29/18	0.00	0.00	Purchasing		AT 18/11/20
110	Packaging	20 pcs		8/29/18	0.00	0.00	Packaging2		AT 18/11/20
120	QC	20 pcs		8/29/18	0.00	0.00	QC6	DAS	AT 18/11/20
130	Packaging	20 pcs		8/29/18	0.00	0.00	Packaging3-2	21	DAS
140	QC21-SA FT	20 ft		8/29/18	0.00	0.00	QC21	9-89	DAS
SEP 19 2018 13 9-89 <i>aug 23. 2018 - 20 A h</i> <i>NOV 21 2018</i>									

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6202P	I Beam Extrusion	20 ft (1 ea)	100-Purchasing - Ft	5119828

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing - Ft	D6202P	20	0	0

Part Specifications

Specifications could not be found.

Plex 8/23/18 8:21 AM dart.Lussier.Patrick



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200

PURCHASE ORDER **PO041074**

Supplier: MES002-VC
Metaux Solutions
2625 boul Jacques-Cartier Est
Longueuil
QC
J4N 1L7 Canada
Phone: 800 558 8858
Fax: 514 633 8044

PO No: PO041074

PO Date: 9/19/18

Due Date: 10/4/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

REVISED

E-MAILED
SEP 20 2018

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1/	182348	D6202P		I Beam Extrusion : AS PER DWG D6202 REV. A MAT'L: 6061- T6/T651 AS PER QQ-A-200/8	Firmed	-	10/23/18	25 ft	0 ft	25 ft	\$80.40/ft	\$2,010.00

Grand Total: \$2,010.00

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/20/18 11:19 AM dart.lavoie.chantal

Shipping Order

16/11/2018

METAUX SOLUTIONS INC
2625 BOUL JACQUES CARTIER EST
LONGUEUIL, QUEBEC
J4N 1L7 **Tel. : 450 641-3330**

Order : 139534
Reference : 41074
Ship : PICK UP / PICK UP

Customer : 6323336**Ship To**

DART AEROSPACE LTD
1270, ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7

Same

Tel. : 1 613 632-3336

Item No.	Description	Qty	Qty. Deliver	B/O Qty
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AI42796326	***** FACTURER E-MAIL ***** SUPER IMPORTANT SUR LE PACKING SLIP INSCRIRE LES HEAT N ALUM I BEAM 4 X 2.796 X .326 1 x 25' ***** ht. 201810390 <i>AT</i>	25	<u>25</u>	<u>Ø</u>
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SHIP JOURNEY COLLECT
JP

Shipping : _____
Package No : _____
Merchandise Received: _____

Ref. : _____



Service Center Metals

5850 Quality Way
Prince George, VA 23875

CERTIFIED INSPECTION REPORT AND TEST RESULTS FOR EXTRUDED PRODUCTS



BILL TO	MANIFEST NUMBER 369464	DIE NUMBER BS0291	DATE OF SHIPMENT 6/8/2018
SHIP TO	CUSTOMER PO 5400403926	ALLOY / TEMPER 6061-T6	SALESPERSON Ellis Williams
Quantity Certified 1,643 lbs 20 pcs	CUSTOMER PART NUMBER ALI00011	DESCRIPTION ASI 4.000x2.796x.326	

OUR ORDER NUMBER 952828	ITEM 1
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CERTIFICATION ASTM-B308-10 SPOT STENCIL
SPECIFICATION ASTM-B221-14
SPECIFICATION SAE AMS-QQA-200/8A Stabilized
SPECIFICATION RoHS 2011/65/EU Compliant

We hereby certify that the material covered by this report has been inspected in accordance with the most recent certification revision, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, and that samples representative of the material met the composition limits and had the mechanical properties shown. Items produced and certified as 6061-T6511 also meet the requirements of 6061-T6.

All aluminum products supplied by Service Center Metals, LLC contain no functional mercury. Neither mercury nor its compounds are used in the manufacture of aluminum products at our facility. Furthermore, aluminum products supplied by Service Center Metals have not, to the best of our knowledge, contacted any source of mercury.

SCM is ISO 9001-2015 certified

This product is RoHS-2, REACH, and DFARS compliant.

Mechanical Properties

Tests	Lot No.	Test Date	Ultimate Tensile Strength (KSI)		Yield Strength (KSI)		Percent Elongation	
2	201810390	6/1/18	min	max	min	max	min	max
			42.80	43.20	40.60	41.20	17.20	18.30

Chemical Composition for Aluminum Alloy 6061

Cast #	Lot No.	Alloy	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	AL	Others Each	Total	Melt Source:
002J180524C	201810390	6061	0.66	0.27	0.21	0.05	0.87	0.07	0.07	0.02	97.79	0.05	0.15	United States of America

SCM products are melted and extruded in the USA

Calvin J. Wiggins, Director of Quality & Technical Services

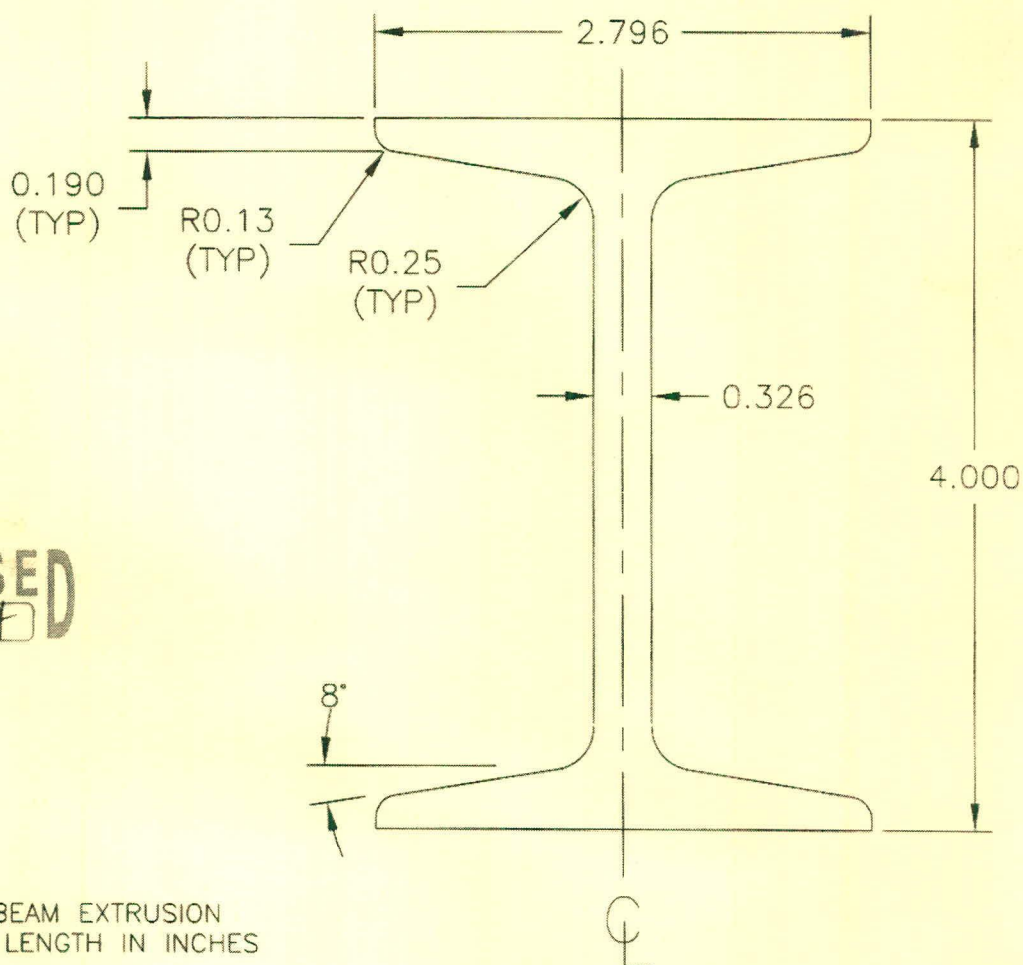
Print Date: 6/8/2018

Rev 3/14/2018



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6202	REV. A SHEET 1 OF 1
DATE 01.04.02		TITLE I-BEAM EXTRUSION	SCALE 1:1
A	01.04.02	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



D6202-XXX I-BEAM EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6202-027 IS 27 INCHES LONG

PURCHASE MATERIAL: AMERICAN STD. I-BEAM
4.000" x 2.796" x 0.326" THICK
6061-T6/T651 (2Q-A-200) (8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6202
DATE: 18/11/20

PO / BATCH NO.: P0041074 / S129539

MATERIAL CERT REC'D: Yes
QUANTITY RECEIVED: 25'
QUANTITY INSPECTED: 25'
QUANTITY REJECTED: 0

THICKNESS ORDERED: 0.326"
THICKNESS RECEIVED: 0.326"
SHEET SIZE ORDERED: —
SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y <u>(N)</u>	
CORRECT FINISH	<u>(Y)</u> N	
CORROSION	Y <u>(N)</u>	
CORRECT GRAIN DIRECTION	<u>(Y)</u> N	
CORRECT MATERIAL PER M-DRAWING	<u>(Y)</u> N	AMS-QQA-200
CORRECT THICKNESS	<u>(Y)</u> N	
PHOTO REQUIRED	Y <u>(N)</u>	
CORRECT REF # TO LINK CERT	<u>(Y)</u> N	HT: 201810340
CORRECT MATERIAL IDENTIFICATION	<u>(Y)</u> N	
CORRECT M# ON THE MATERIAL	<u>(Y)</u> N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y <u>(N)</u>	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y <u>(N)</u>	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>AT</u>	SIGNED OFF BY: _____
DATE: <u>18/11/20</u>	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

